

Work Order ID 46180

June 29, 2009 10:37:09 AM



Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

09-09-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

8 09/09/22

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971 2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188 3-Deburr 4-Install inserts in D3188-2 as per Dwg D3188.

⇒ RT 09-09-16

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

⇒ 8 09/09/16

ⓧ 4

Work Order ID 46180

June 29, 2009 10:37:09 AM



Page 2

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

Small Fab

→ NYA
cut off water jet
as per B# 48237

140

0.00



Small Fab

Small Fab

Memo

0.00

****This step separates hardware, previous steps is for body & floor****

Small Fab

glue 2986 neoprene foam
to floor using contact adhesive

RT 09-09-16

B 112225

150

0.00



Small Fab

Small Fab

Memo

0.00

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Small Fab

Hardware on previous steps is for door ass'y 1-Drill and plug section I-I
and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to
weight. ICA/R Hysol batch: 112 099

exp: 10/6/19
milled fibre B 100859

RT 09-09-16

Work Order ID 46180

June 29, 2009 10:37:09 AM



Page 3

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part/Finish

Memo

u/a S 09/02/16

0.00

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> S 09/02/16

180



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

u/a S 09/02/16

wing walk as per Draw. 6 Batch: m112100

x1 m112100 09/09/16

Work Order ID 46180

June 29, 2009 10:37:09 AM



Page 4

Item ID: D350-600-242

Revision ID: C

Item Name: Spacepod, RH, AS350/355

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

210

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

BK 09-09-17

①

9/9/21 ① SP

⇒ 8/2/22

④

Work Order ID 46180

June 29, 2009 10:37:09 AM



Page 5

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-600-141: Location: _____ PPP Rev: B

Packaging

230

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

9/9/22 10 Sp

09/09/29 JF

16 22-08-28

Picklist Print

June 29, 2009 10:37:07 AM

Page 1

Work Order ID: 46180

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod. RH, AS350/355

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			110	Each	7,849.000	28.0000			
Insert												
D3186-4RevD		Manufactured	No			110	Each	0.0000	1.0000			
Spacepod Door, RH												
D3187-2RevC		Manufactured	No			110	Each	7.0000	1.0000			
Spacepod Floor												
D3188-2MRevE		Manufactured	No			110	Each	0.0000	1.0000			
SPACEPOD BODY RH												
D3015-3RevB		Manufactured	No			120	Each	435.0000	1.0000			
Locknut												
A3235-020-935		Purchased	No			130	Each	815.0000	8.0000			
Washer - Countersunk												
AN526C832R24		Purchased	No			140	Each	144.0000	4.0000			
screw												
AN960JD516		Purchased	No			140	Each	1,603.000	1.0000			
Washer												
AN960JD8		Purchased	No			140	Each	1,143.000	4.0000			
Washer												

M110511 SP

ET 09-09-09

~~ET 09-09-09~~ B31836 ET 09-09-15

ET 09 09-09

~~ET 09-09-09~~

M106150 SP

M104603 SP

M202082 SP

M111578 9/7/10 (x) SP

Picklist Print

June 29, 2009 10:37:08 AM

Page 2

Work Order ID: 46180

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
X D2179RevB 		Manufactured	No			140	Each	95.0000	2.0000			
Doubler												
X D2237RevD1 		Manufactured	No			140	Each	30.0000	2.0000			
Striker Plate												
X D2986RevB 		Manufactured	No			140	sf	0.0000	5.9158			
Black Neoprene Foam .125												
X D3015-3RevB 		Manufactured	No			140	Each	435.0000	1.0000			
Locknut												
X D3538-1RevA 		Manufactured	No			140	Each	40.0000	2.0000			
Hinge Bracket												
X D3554-7RevA 		Manufactured	No			140	Each	81.0000	1.0000			
Ball Stud												
X D3567-2RevA 		Manufactured	No			140	Each	13.0000	1.0000			
Decal												
X MS20426AD4-5 		Purchased	No			140	Each	7,958.000	4.0000			
Rivet												
X AN526C832R10 		Purchased	No			150	Each	195.0000	8.0000			
Screw												

B 35432 SP

B50348 SP

B348237 ET 09-09-15

48238 SP

B46758 B48197 SP

37674 SP

B50375 SP

M8067 SP

M104603 9/9/10 @ SP

June 29, 2009 10:37:08 AM

Shop Packet Print

Page 2

Picklist Print

June 29, 2009 10:37:08 AM

Page 3

Work Order ID: 46180

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
<input checked="" type="checkbox"/> AN526C832R14 		Purchased	No			150	Each	1,051.000	2.0000			
Screw												
<input checked="" type="checkbox"/> AN960JD10 		Purchased	No			150	Each	1,246.000	2.0000			
Washer												
<input checked="" type="checkbox"/> AN960JD8 		Purchased	No			150	Each	1,143.000	4.0000			
Washer												
<input checked="" type="checkbox"/> D2228RevB 		Manufactured	No			150	Each	120.0000	4.0000			
Bracket Plate												
<input checked="" type="checkbox"/> D2464RevB 		Manufactured	No			150	f	896.4300	11.3684			
3/4 Seal												
<input checked="" type="checkbox"/> D2585RevB 		Manufactured	No			150	Each	22.0000	2.0000			
Mounting Channel												
<input checked="" type="checkbox"/> D2586RevD 		Manufactured	No			150	Each	80.0000	2.0000			
Door Latch												
<input checked="" type="checkbox"/> D2621RevB 		Manufactured	No			150	Each	91.0000	2.0000			
Latch Plate, 350 Spacepod												
<input checked="" type="checkbox"/> D2857-1RevB 		Manufactured	No			150	Each	30.0000	1.0000			
Hinge Bracket												

M104916 SP

M111279 SP

M111578 SP

B30679 SP

KT 09-09-15

B50544 SP

B47183 SP

B41175 SP

B45788 9/10 @ SP

June 29, 2009 10:37:08 AM

Shop Packet Print

Page 3

Picklist Print

June 29, 2009 10:37:08 AM

Page 4

Work Order ID: 46180

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH. AS350/355










Comments:


Start Date: 15/07/2009


Required Date: 03/08/2009


Start Qty: 1.00


Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2857-2RevB 		Manufactured	No			150	Each	38.0000	1.0000			
Hinge Bracket ✓ D3557-1RevA 		Manufactured	No			150	Each	18.0000	1.0000			
Bracket ✓ D3567-2RevA 		Manufactured	No			150	Each	13.0000	1.0000			
Decal ✓ MS21042L08 		Purchased	No			150	Each	306.0000	4.0000			
Nut ✓ MS21042L3 		Purchased	No			150	Each	1,873.000	2.0000			
Nut ✓ MS27039-08-11 		Purchased	No			150	Each	139.0000	2.0000			
Screw ✓ MS27039-1-15 		Purchased	No			150	Each	116.0000	2.0000			
Screw ✓ NAS1515H3 		Purchased	No			150	Each	530.0000	2.0000			
Washer ✓ AN526C832R10 		Purchased	No			200	Each	195.0000	2.0000			
Screw												


 B45797 sf

 B32647 sf


 B39678 sf


 M112492 sf

 M111274 sf

 M111977 sf

 M111916 sf

 M111268 sf

 M104603 9/9/10 @sf

June 29, 2009 10:37:08 AM

Shop Packet Print

Page 4

Picklist Print

June 29, 2009 10:37:08 AM

Page 5

Work Order ID: 46180

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355








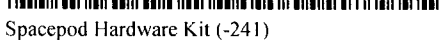
Comments:









Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 		Purchased	No			210	Each	1,603.000	2.000 3.00			
Washer D2985RevA1 		Manufactured	No			210	Each	19.0000	1.0000			
Label D350-600-449RevC1 		Manufactured	No			210	Each	7.0000	1.0000			
Switch Relocation D3547-1RevA 		Manufactured	No			210	Each	20.0000	1.0000			
Bracket D3550-1RevB 		Manufactured	No			210	Each	31.0000	1.0000			
Strut D3552-7RevD1 		Manufactured	No			210	Each	16.0000	1.0000			
Door Prop D3554-7RevA 		Manufactured	No			210	Each	81.0000	1.0000			
Ball Stud K10021RevN/A 		Manufactured	No			210	Each	5.0000	1.0000			
Spacepod Hardware Kit (-241)												

 M112082 SP
 B48236 SP
 41358 SP
 B35455 SP
 B45570 SP
 B32644 SP
 ~~B37674 9/9/10~~ B37674 9/9/21 SP
 B48266 9/9/21 @ SP

June 29, 2009 10:37:08 AM

Shop Packet Print

Page 5

Date: Monday, 02/03/2009 11:25:01 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number : 46180	
Estimate Number : 12779	
P.O. Number :	Part Number : D350600242
This Issue : 02/03/2009 S.O. No. :	Drawing Number : IIN REV.C PG11,18-21
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 39650	Material :
Written By :	Due Date : 30/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.03.02</u>	
Comment : Est Rev:A 07.03.07 new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC Est Rev:C 08-09-30 add primer in step 44 DD verified by:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

✓ DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

2.0

✓ 46180A

SPACEPOD BODY RH

**Comment:** Sub-Component SPACEPOD BODY RH

1 x D3188-2M Batch

3.0

✓ 46180B

SPACEPOD DOOR RH

**Comment:** Sub-Component SPACEPOD DOOR RH

1 x D3186-4 Batch

4.0

✓ D31872

Spacepod Floor

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2 Floor

5.0

✓ ALS41032130

Insert

**Comment:** Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer - Countersunk

7.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes in D3188-2 using drill jig DT8971

2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188

3-Deburr

4-Install inserts in D3188-2 as per Dwg D3188.

8.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0



D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

neoprene foam

batch: _____

10.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

11.0



D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: _____

12.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

☒ AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: _____

14.0

☒ D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: _____

15.0

☒ D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

16.0

☒ MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: _____

17.0

☒ D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: _____

18.0

☒ D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

19.0

☒ AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

☒ AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

21.0

☒ MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: _____

22.0

☒ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step seperates hardware, previous steps is for body & floor****

23.0

☒ MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

24.0

☒ AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

25.0

☒ NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

26.0

☒ MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 112492

BT 09-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

☒ D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)
3/4 Seal

Cut 127.00" long batch: _____

28.0

☒ D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: _____

29.0

☒ D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Door Latch
batch: _____

30.0

☒ D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Clamp
batch: _____

31.0

☒ D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Plate
batch: _____

32.0

☒ MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: _____

33.0

☒ AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

☒ MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

35.0

☒ D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

36.0

☒ D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

37.0

☒ D2228

Bracket Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: _____

38.0

☒ AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: _____

39.0

☒ AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: 111578

RT 09-09-16

40.0

☒ MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: 112492

RT 09-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

✓ D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

42.0

✓ AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

43.0

✓ AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

44.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: _____ expire date: _____

A/R Milled fibres batch: _____

2- Prime (grey) as necessary per QSI005

Primer batch: _____

Hardner batch: _____

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: _____

45.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

47.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: _____

48.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

49.0



K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

50.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

51.0



D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

52.0



D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

batch: _____

53.0



D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

✓ D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: _____

55.0

✓ D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: _____

56.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: _____

57.0

✓ AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

58.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 48238

45 09-09-16

59.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

60.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: _____

PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 46180

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion ✓



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

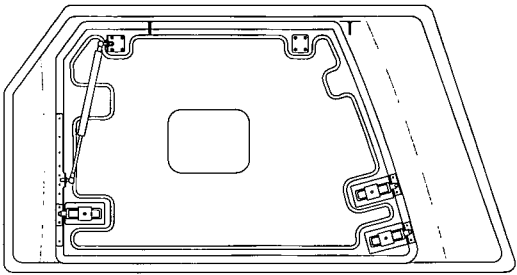
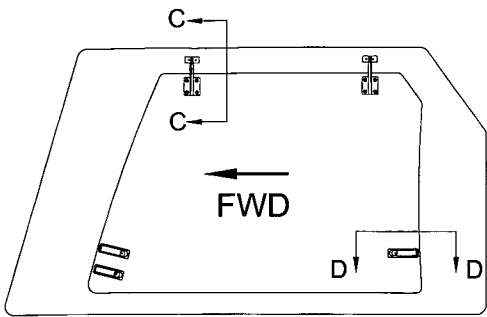


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

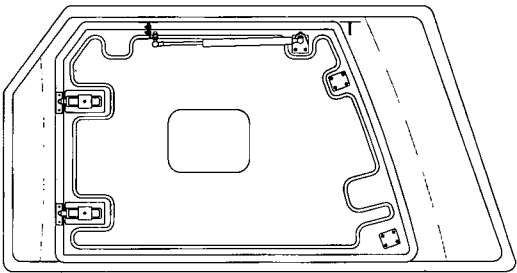
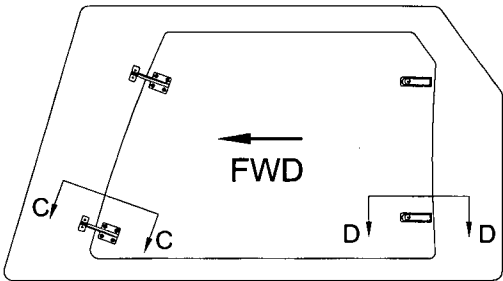
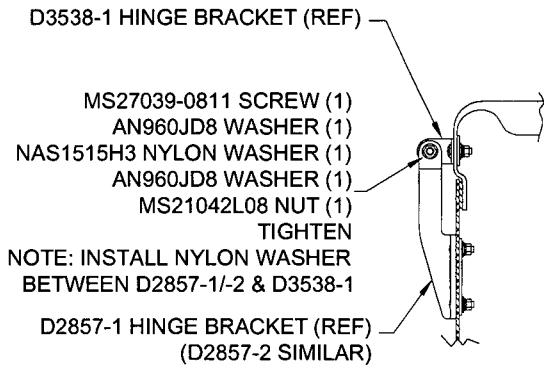
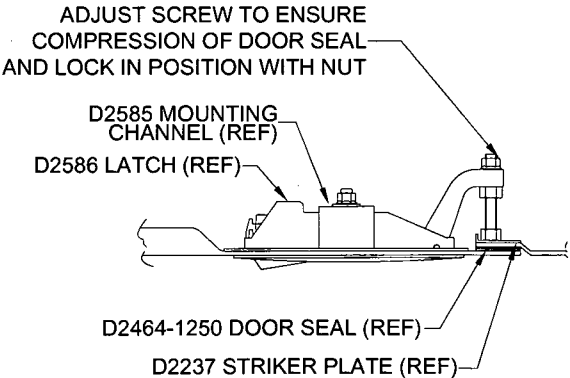


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 11180

• COPYRIGHT © 2006 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: C

Date: 07.02.20

3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.

3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

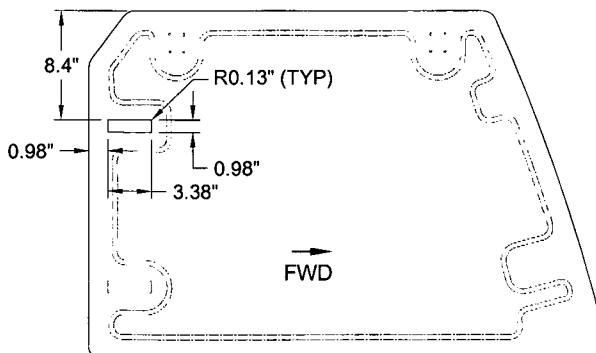


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

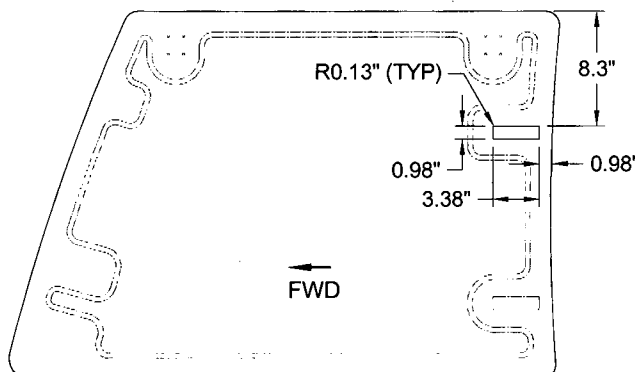


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

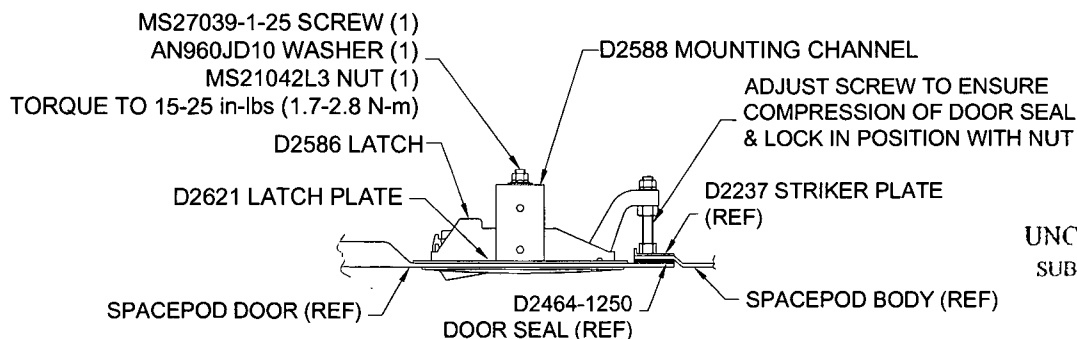


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46180

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

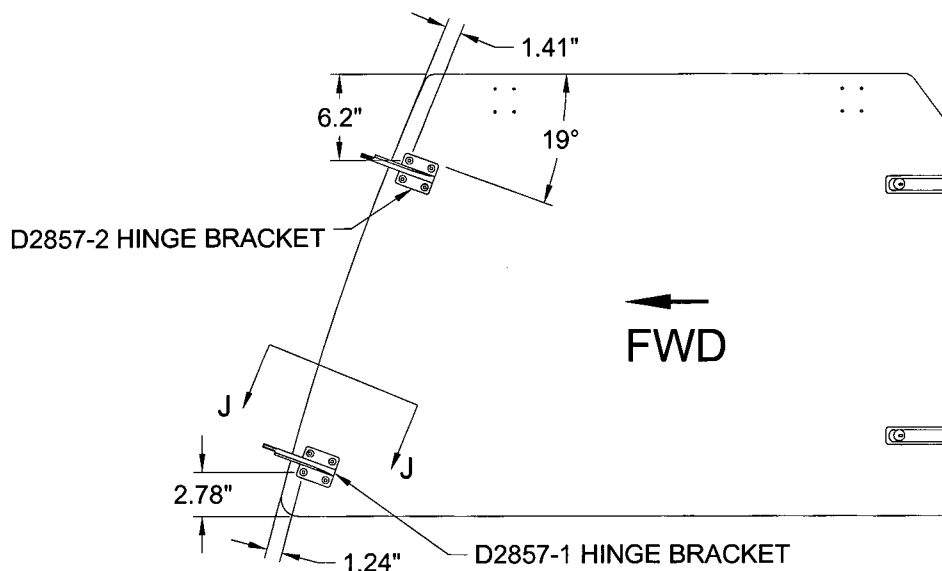


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

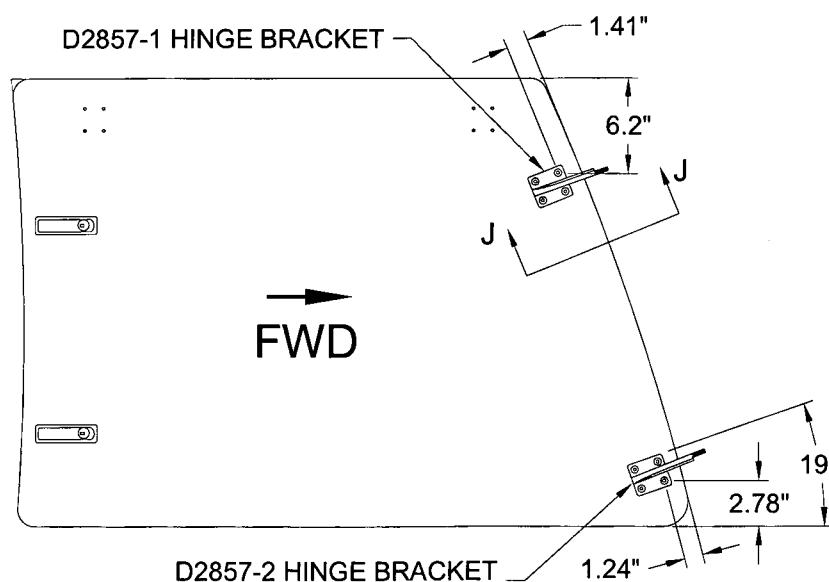
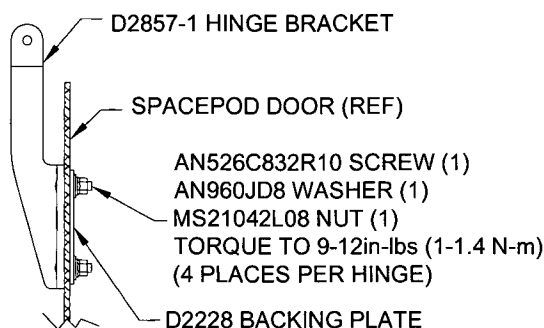


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 100180



SECTION 'J-J' HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

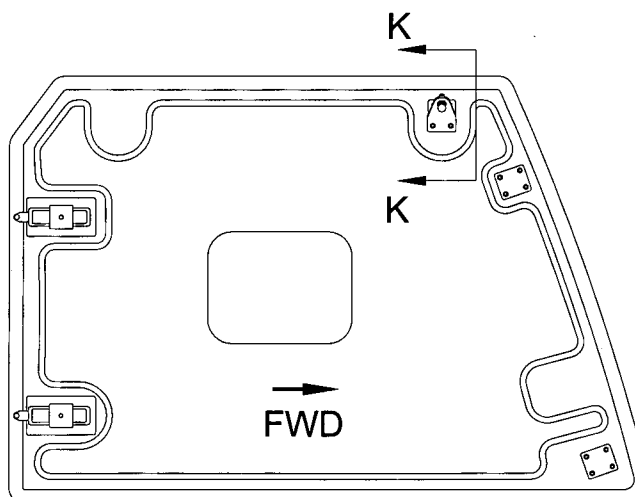
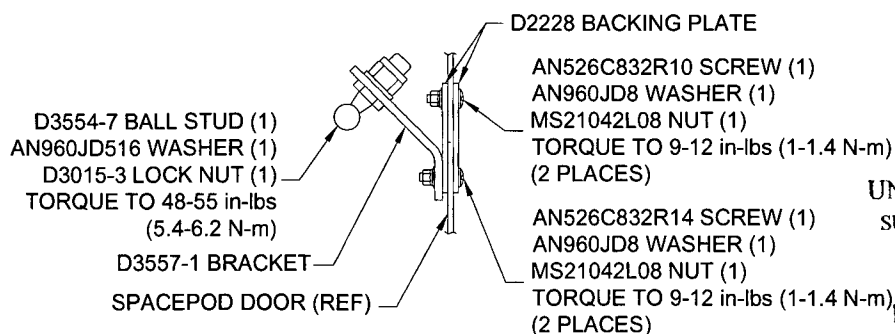


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 450180

SECTION 'K-K'

• COPYRIGHT © 2006 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **C**
Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill $\varnothing 0.375$ " holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the $\varnothing 0.172$ " D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

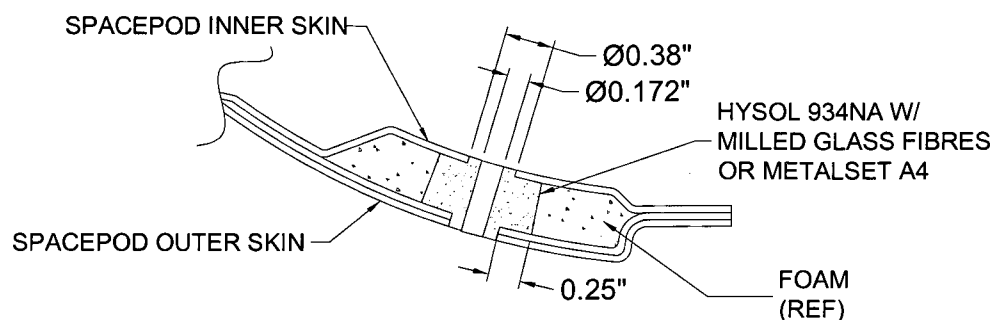


FIGURE 17(a). COMPOSITE MODIFICATION

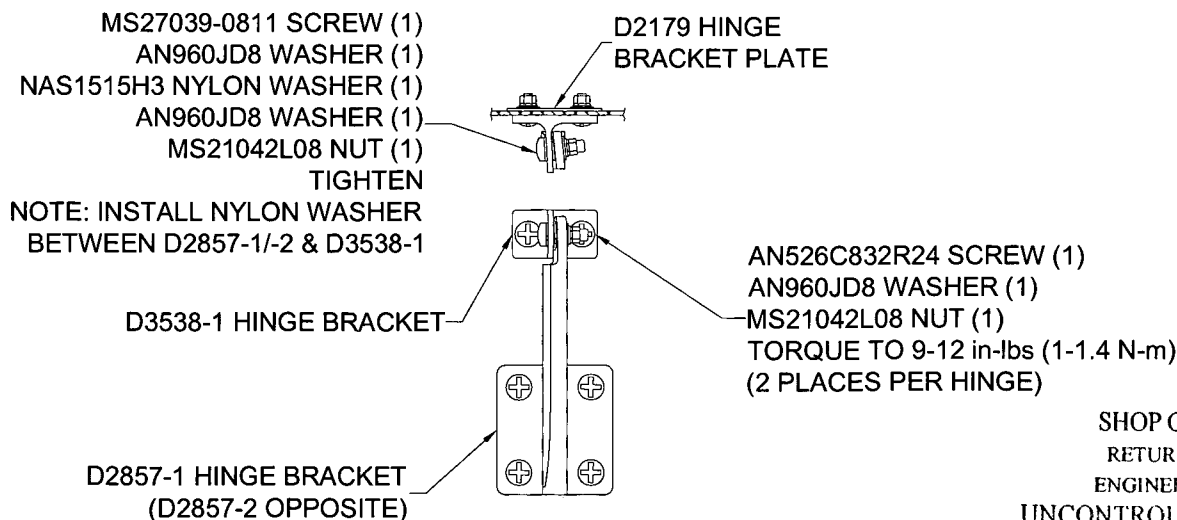


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40080